

SC-414S

Features

- Cored wire for submerged arc hardfacing
- Martensitic stainless steel type
- SAW Process (with S-717/S-401HF flux)

Polarity

DC +

Application Areas

- Continuous casting rolls, steel mill rolls

Shielding Gas

None

Typical Chemical Composition of All-Weld Metal (wt%)

Wire size	C	Si	Mn	Ni	Cr	Mo	Nb	V
3.2(1/8)	0.11	0.7	1.5	2.6	13.9	1.1	0.2	0.2

Typical Mechanical Properties of All-Weld Metal

Item	HRC (≥4Layers)
S-717	42~46

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)
2.4(3/32)	300~400
3.2(1/8)	350~450

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Packaging
2.4(3/32)	Coil 25kg(55lbs), Drum 150kg, 250kg
3.2(1/8)	

SWAW

GMW

GTAW

FCW

Metal-cored Wire

SAW Wire

SAW Flux